

Date: Wednesday, 2/15/2006 3:46:59 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BAR
Job Number	: 25849		
Estimate Number	: 10386		
P.O. Number	: N/A	Part Number	: D31961
This Issue	: 2/15/2006 S.O. No. : N/A	Drawing Number	: D3196 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25242	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 3/3/2006
Checked & Approved By	: 06.02.16	Qty:	20 Um: Each
Comment	: Est Rev: A New Issue 05-11-08 JLM		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"	
Comment: Qty.: 2.2922 f(s)/Unit Total : 45.8430 f(s)		M100157 (44 feet x 2 pcs)	
Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)		M18571 (28.5 feet, 13 pcs) En 06/02/24	
(M6061T6B0.750x01.500)		SA 06.02.21	
Identify for D3196-1 (7 pcs)			
Batch: M18601 (15.3 feet)			
2.0	BAND SAW	BAND SAW	
Comment: BAND SAW			
Cut blank: (0.75" x 1.50") x 26.200" long Bar		SA 06.02.21	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1			
1-Machine D3196-1 as per Folio FA339 and Dwg D3196 Identify as D3196-1			
2-Deburr		SA/J.L. 06.02.25	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		SA/J.L. 06.02.25	
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK		J.L. 06.02.25	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PS Date: 06/03/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 2/15/2006 3:46:59 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 25849

Part Number: D31961

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*ml* 06 02 28

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*am* 06-02-28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*ml* 06 03 01

*2/0*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5+134*

*PC 8/3/01* (40)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*Q* 06/03/01

Job Completion



*u* 06-03-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	25849
<b>Description: Bar</b>		<b>Part Number:</b>	D3196-1
<b>Inspection Dwg: D3196 Rev: A</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.094	+/-0.010	26.094	✓			m-tape
4.083	+/-0.010	4.083	✓			
17.928	+/-0.005	17.927	✓			
0.750	+/-0.005	.751	✓			
1.500	+/-0.010	1.505	✓			
Ø0.344	+0.005/-0.000	.345	✓			
Ø0.660 x 100°	+/-0.005	.665x100°	✓			
0.060 x 45°	+/-0.010	.070	✓			
0.750	+/-0.010	.752	✓			
0.250	+/-0.010	.255	✓			
3.583	+/-0.010	3.584	✓			
9.000	+/-0.010	8.999	✓			
16.844	+/-0.010	16.843	✓			
21.511	+/-0.010	21.510	✓			
R0.125	+/-0.010	.125	✓			
1.000	+/-0.010	.998	✓			
R0.125	+/-0.010	.125	✓			

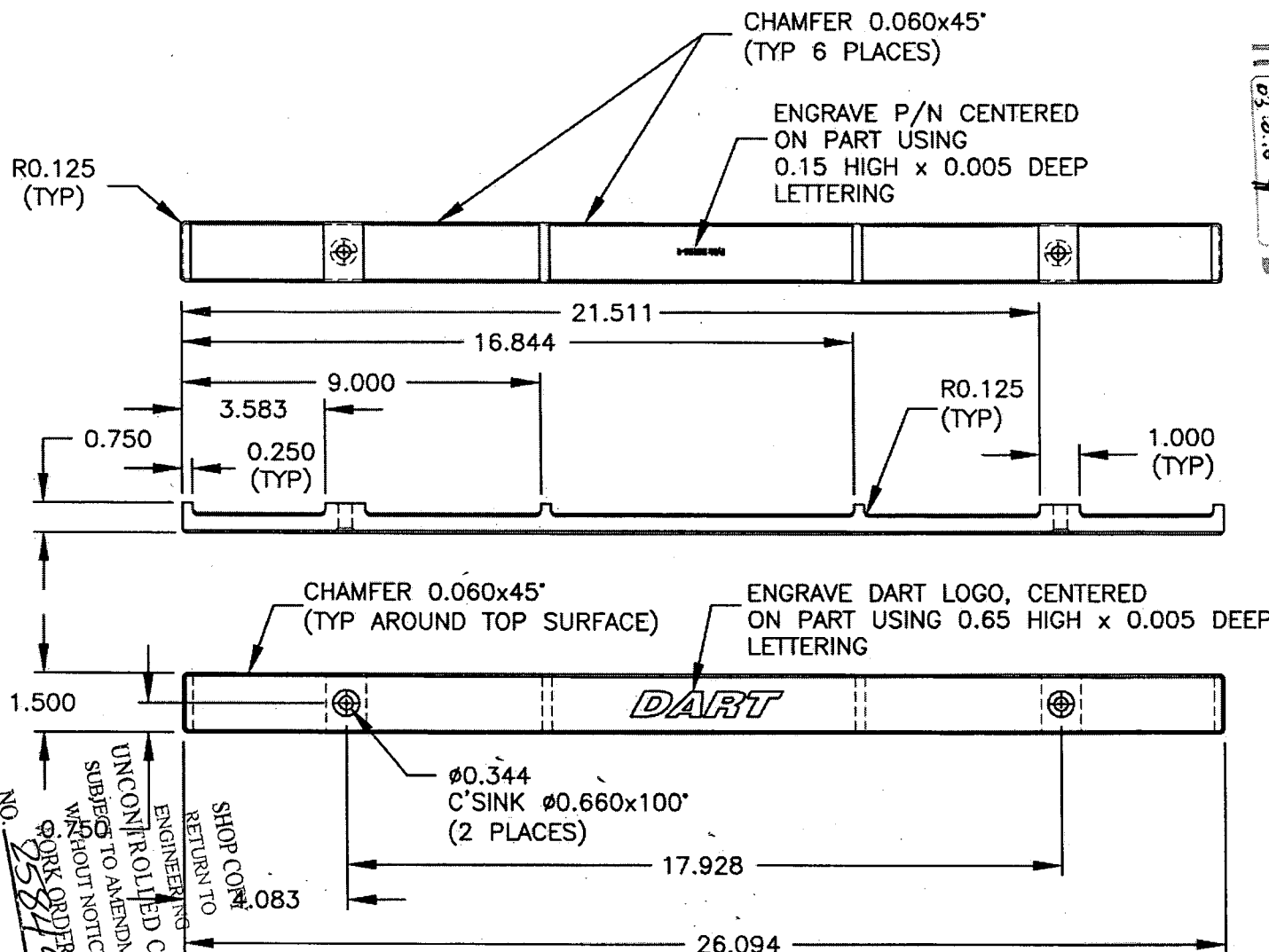
<b>Measured by:</b>	JL	<b>Audited by:</b>	MS	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06-02-24	<b>Date:</b>	06/02/24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-01/-013)	KJ/RF	



RELEASED  
03.06.25

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	REV. A
DATE	03.06.25	DRAWING NO.	D3196	SHEET 1 OF 3
		TITLE	BAR	SCALE
A		03.06.25	NEW ISSUE	1:4



#### D3196-1 BAR

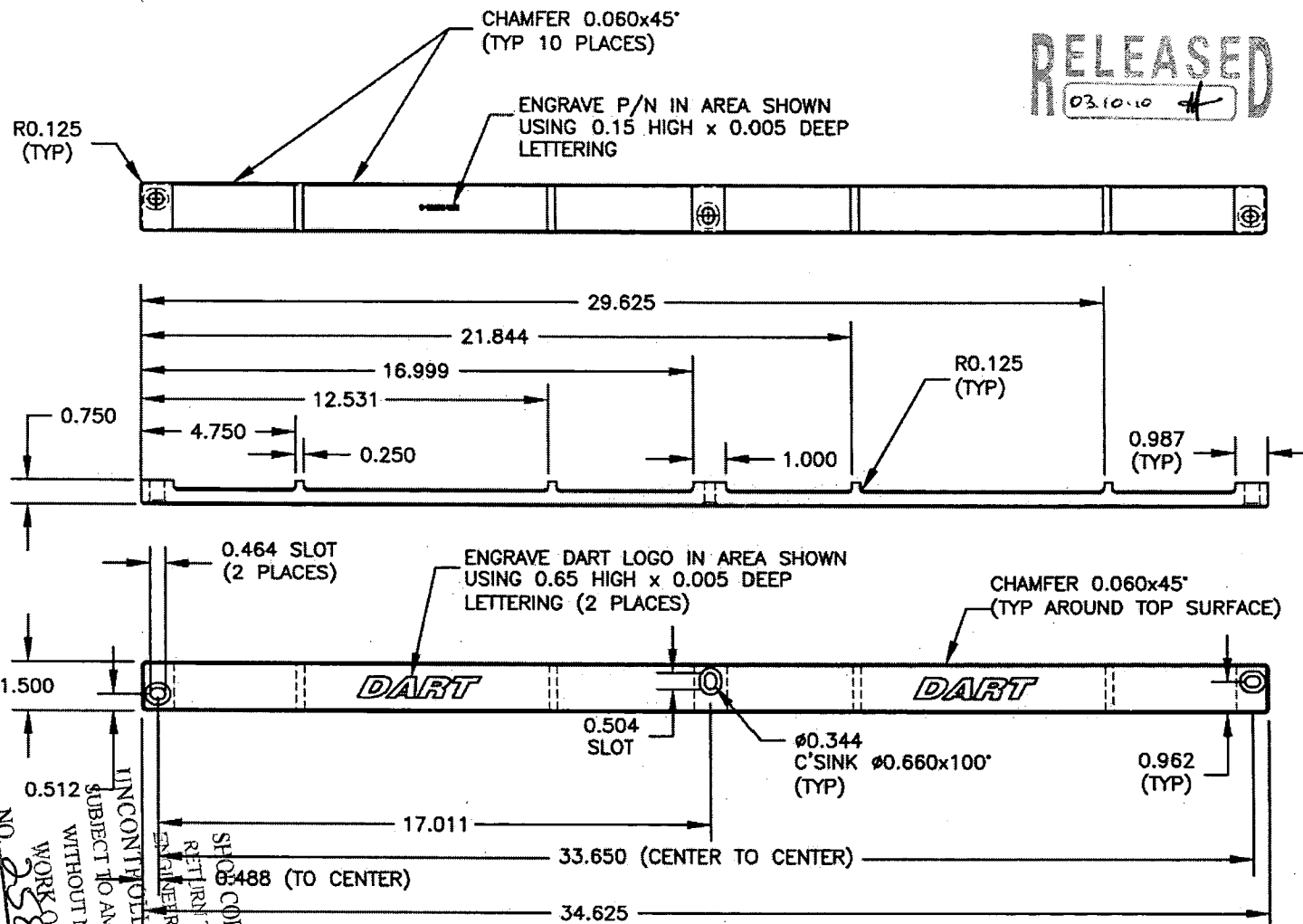
- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED  
03.10.10

**DART**



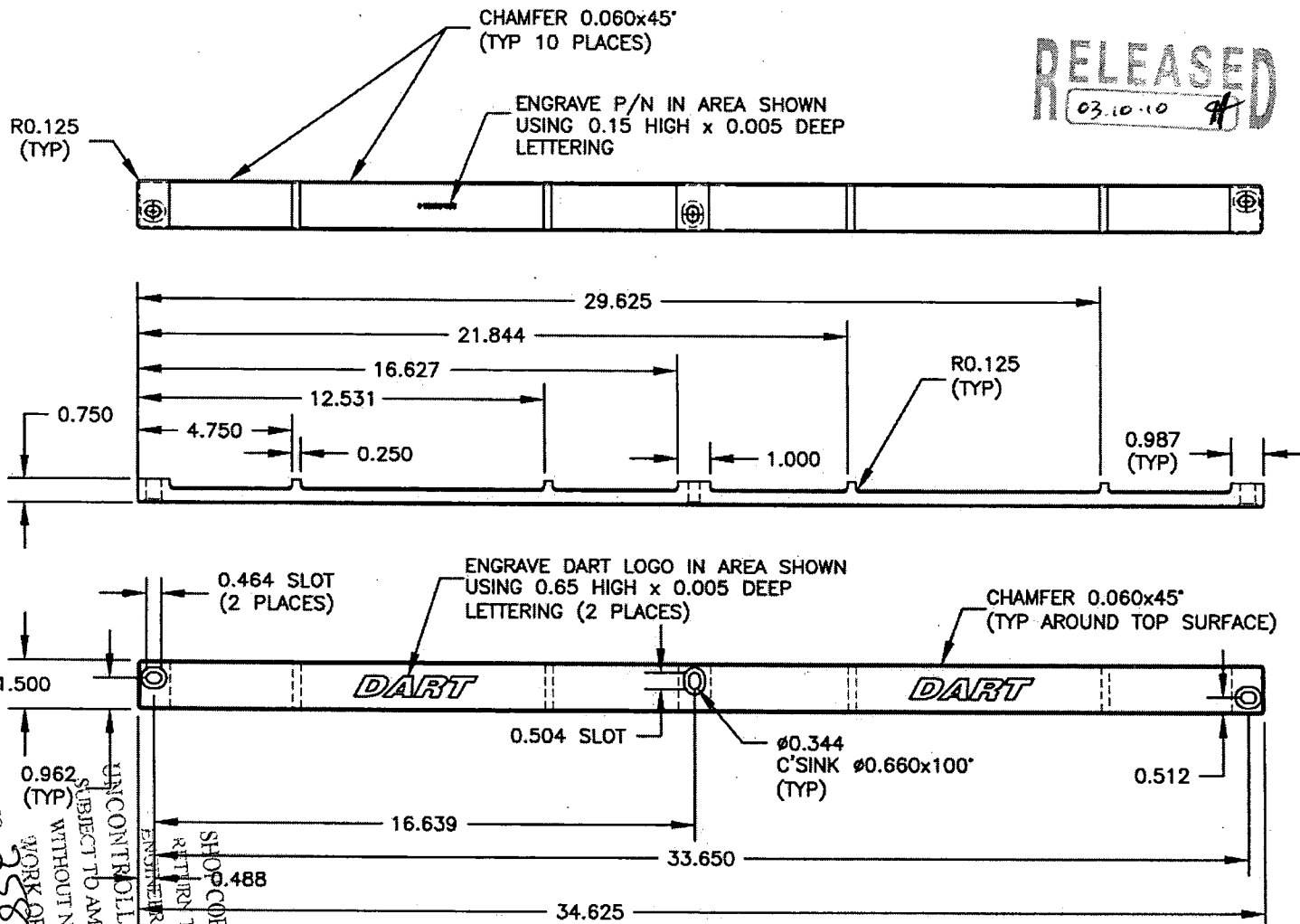
DESIGN	03	DRAWN BY	03	<b>DART AEROSPACE LTD</b>
CHECKED	03	APPROVED	03	HAWKESBURY, ONTARIO, CANADA
DATE	03.06.25	DRAWING NO.	D3196	REV. A
		TITLE	BAR	SHEET 2 OF 3
		SCALE	1:5	



D3196-3 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED  
03.10.10

**DART**



DESIGN	03.06.25	DRAWN BY	03.06.25	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		REV. A
DATE	03.06.25	TITLE	D3196	SHEET 3 OF 3
			BAR	SCALE 1:5





Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.  
Job Number : 29986  
Estimate Number : 10804  
P.O. Number : N/A  
This Issue : 15/12/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : 00015  
Written By :  
Checked & Approved By :  
Comment :

Drawing Name : D3196-1  
Part Number : D31961  
Drawing Number : REWORK-ECN871  
Project Number : N/A  
Drawing Revision : N/A  
Material : N/A  
Due Date : 22/12/2006  
Qty: 16 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

-REMOVE FROM STOCK:

D3196-1 B25848 8X

B25108 1X

B25100 1X

1X from kits (1-X)

D412-702-021 B26883 3X

B25853 1X

D412-702-023 B26074 3X B27722 1X

B25705 2X

D412-702-033 327 935 1X

(AND FROM WIP)

D412-702-011

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE ALL D3196-1'S FROM KITS

3.0

D31961

Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s)  
Bar

4.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

REWORK D3196-1  
PER ECN 871

06/12/18

16

Date: Friday, 15/12/2006 9:48:32 AM  
 User: Linda Lacelle

## Process Sheet

B.25849

Customer : CC-DAR01 Dart Aerospace Ltd.  
 Job Number : 29986  
 Estimate Number : 10804  
 P.O. Number : N/A  
 This Issue : 15/12/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : MACHINED PARTS  
 Previous Run : 00015  
 Written By :  
 Checked & Approved By :  
 Comment :

Drawing Name : D3196-1  
 Part Number : D31961  
 Drawing Number : REWORK-ECN871  
 Project Number : N/A  
 Drawing Revision : N/A  
 Material : N/A  
 Due Date : 22/12/2006

Qty: 16 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

-REMOVE FROM STOCK:

D3196-1 B25849 8X B25108 1X B25100 1X frank's (10X)

D412-702-021 B26883 3X B25853 1X (4)

D412-702-023 B26074 3X B27835 1X B25765 2X (5)

D412-702-033 327 935 1X (1)

(AND FROM WIP)

D412-702-011

PC 4/12/18

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE ALL D3196-1'S FROM KITS

3.0 D31961 Bar



Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)

Bar

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

REWORK D3196-1  
 PER ECN 871

06/12/18

16